

Date: Friday, 17/10/2008 12:44:33 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ACCESS PANEL ASS'Y
Job Number	: 42729		
Estimate Number	: 13541		
P.O. Number	:	Part Number	: D3307041
This Issue	: 17/10/2008 S.O. No. :	Drawing Number	: D3307 REV. A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 41034	Material	:
Written By	:	Due Date	: 05/11/2008 Qty: 6 Um: Each
Checked & Approved By	: <u>JUD 08.10.17</u>		
Comment	: Est: A 08.08.05 New issue EC verified by:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S22GA	304/316 .032 Sheet
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Comment: Qty.: 0.2600 sf(s)/Unit Total : 1.5600 sf(s)
304/316 .032 Sheet
batch: 109057 B8-10-22

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut D3307-1 as per Dwg D3307
Dwg Rev: A B8-10-22
Prog Rev: A
2-Deburr if necessary B8-10-22

7

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

508/10/22 (X7)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
bend as per dwg D3307

CP 508/10/23 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/10/2008 12:44:33 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASS'Y

Job Number: 42729

Part Number: D3307041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D33073

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Gasket

B 41057 (TX)

B 42762 (6X)

08/10/27

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Bond gasket as per dwg D3307

08/10/27

(7)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/27 (X2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 111

8/10/27

(TX)

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/27

Job Completion



08/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

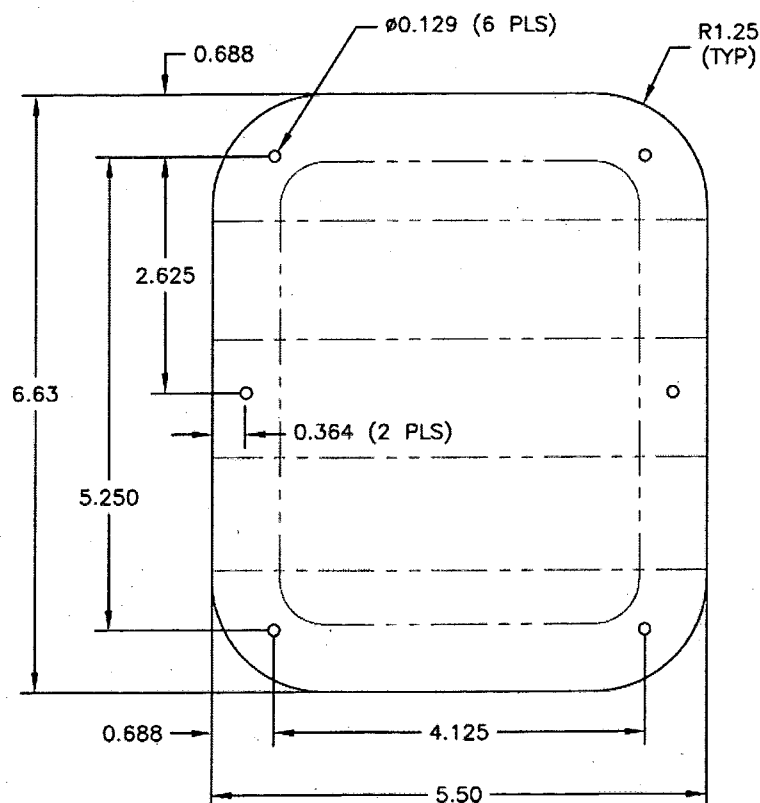
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

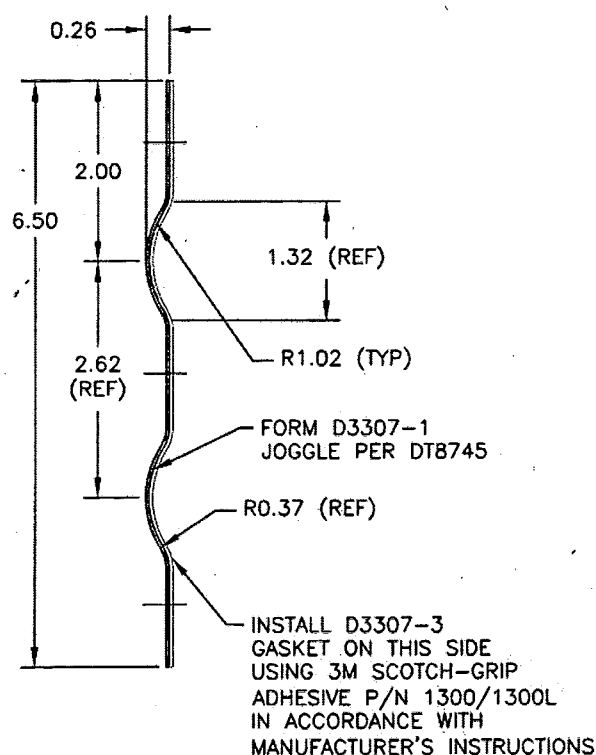


DESIGN JT	DRAWN BY JT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3307	REV. A SHEET 1 OF 2
DATE 04.09.23		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2
A	04.09.23	NEW ISSUE	

RELEASED
05.01.18



D3307-1 PANEL FLAT PATTERN



D3307-041 BEND DETAIL

IDENTIFY WITH P/N & B/N
USING FINE POINT
PERMANENT MARKER

D3307-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO:
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42729

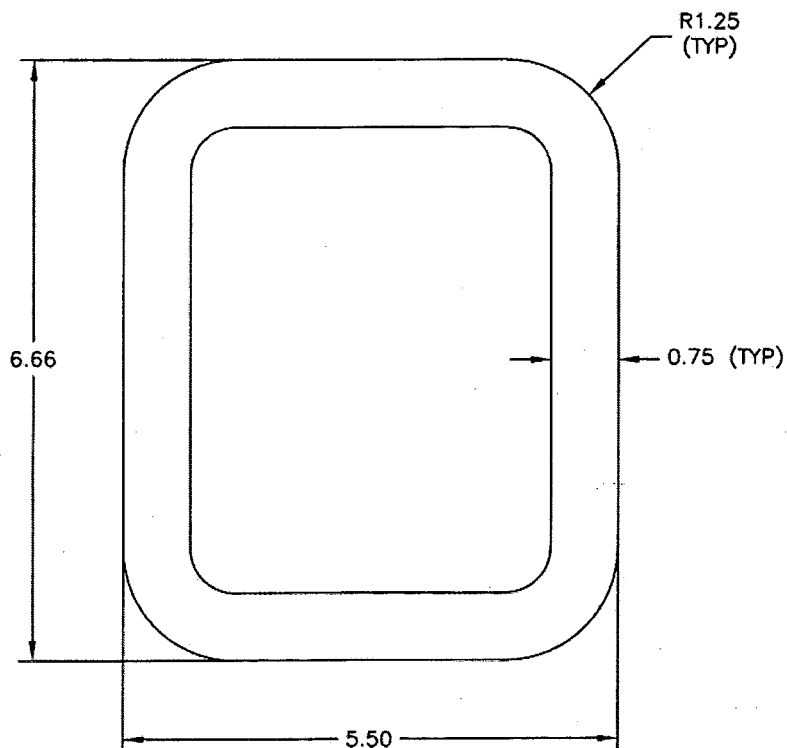
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DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3307	REV. A SHEET 2 OF 2
DATE 04.09.23		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2

RELEASED
65-01.18 [Signature]



D3307-3 GASKET

D3307-3 NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET 0.035 THICK MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2) OR MIL-G-12803A (GRADE P-1161A)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD	Work Order:	42729
Description: ACCESS PANEL	Part Number:	D3307-1
Inspection Dwg: D3307-041, Rev: A		Page 1 of 1


FIRST ARTICLE INSPECTION CHECKLIST

x	First Article
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X Prototype

[illegible]

Measured by:	JB
Date:	8-10-22

Audited by:	
Date:	08/10/22

Prototype Approval:	<i>[Signature]</i>
Date:	<i>[Signature]</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	